

Work Order ID 86778

86778

Page 1

July-06-12 2:45:28 PM

Item ID: D3204-11 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Plate
 Start Date: 7/06/12 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 8/03/12 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: Date: 2-07-9 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | (12) | | | |
| D3204 | Rev A1 | | | | | | | | |
| 100 | FLOW WATER JET | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| Waterjet | Memo | 0.00 | | | | | | | |
| FLOW CNC Waterjet | 1-Cut as per Dwg D3204 Dwg Rev: <u>A1</u> Prog Rev: <u>A1</u> 2- | | | | | | | | |
| 6061 .375x 6000 | Deburr if necessary | | | | | | | | |
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 120 | CONVENTIONAL MILLING MACHINE | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| Mill Conv | Memo | 0.00 | | | | | | | |
| Conventional Milling Machine | 1-Face to size .300" 2-Open hole to .191" as per Dwg D32043-Deburr | | | | | | | | |

B12-7-19

B12-7-19

12-7-26

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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 Required Date: 8/03/12 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|----------------------------|--------------|---------------|---------------|------------------|----------------|
| 130 *130* QC Quality Control | QC2- Inspect parts off machine FAI/FAIB Memo | 0.00 0.00 | | 10 12-7-26 | | 12 | | | |
| 140 *140* QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | DAS 14 2-89 12/07/26 | | 12 | 10 | | |
| 150 *150* Packaging Packaging | Identify as per dwg & Stock Location: <u>W/A</u> Memo *****STOCK IN LARGE FAB***** | 0.00 0.00 | | | | 17 | | 12-7-26 | |

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NOTE: Date & initial all entries

Work Order ID 86778***86778***

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July-06-12 2:45:28 PM

Item ID: D3204-11

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plate

Start Date: 7/06/12

Start Qty: 10.00

10

Cust Item ID:

Required Date: 8/03/12

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00


160

QC

Memo

0.00

Quality Control

12/7/30 

MLJ 12/07/26

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

July-06-12 2:45:28 PM

Page 1

Work Order ID: 86778

Parent Item: D3204-11

Parent Item Name: Plate

Start Date: 7/06/12

Required Date: 8/03/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C05.08.11Added Step 25 KJ/JLM
IPP Rev:D Now on Waterjet 08-01-08 JLM Verified By:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B0.375X01.000 6061T6 BAR .375 x 1.00 | | Purchased | No | | | 100 | f | 26.8760 | 0.1063 | 1.118947 | | | |

1312-7-19

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT001 | 2.292 | |
| 118641 | 2.292 | |
| MAT002 | 24.584 | |
| 120603 | 0.76 | |
| 120866 | 0.76 | |
| 121192 | 0.046 | |
| 121836 | 23.018 | |

121836

(12)

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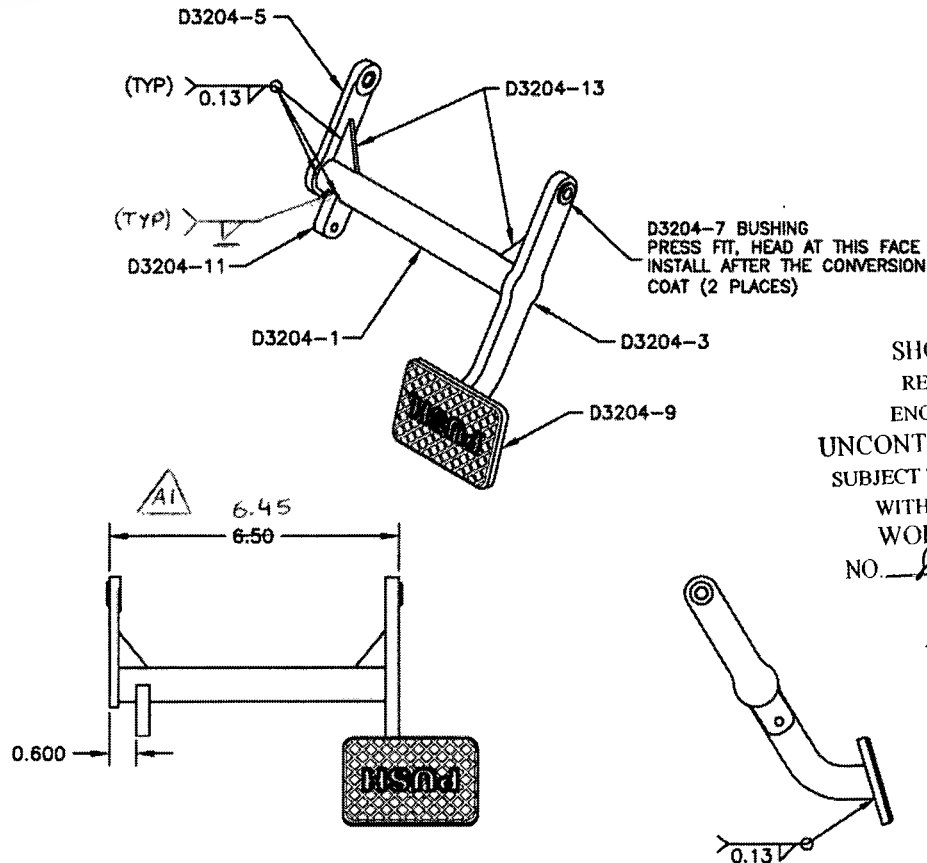
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| CHECKED | APPROVED | DRAWING NO. D3204 | REV. A SHEET 1 OF 3 |
| DATE 04.01.27 | TITLE RELEASE PEDAL ASSEMBLY | | SCALE NTS |
| A | 04.01.27 | NEW ISSUE | |
| A1 | 05.07.15 | 6.45 WAS 6.50 | |

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04.04.30



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86778
R/2-079

D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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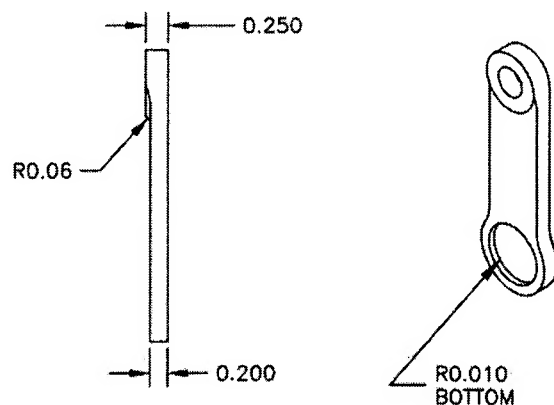
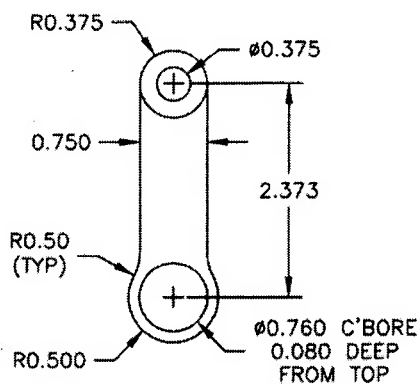
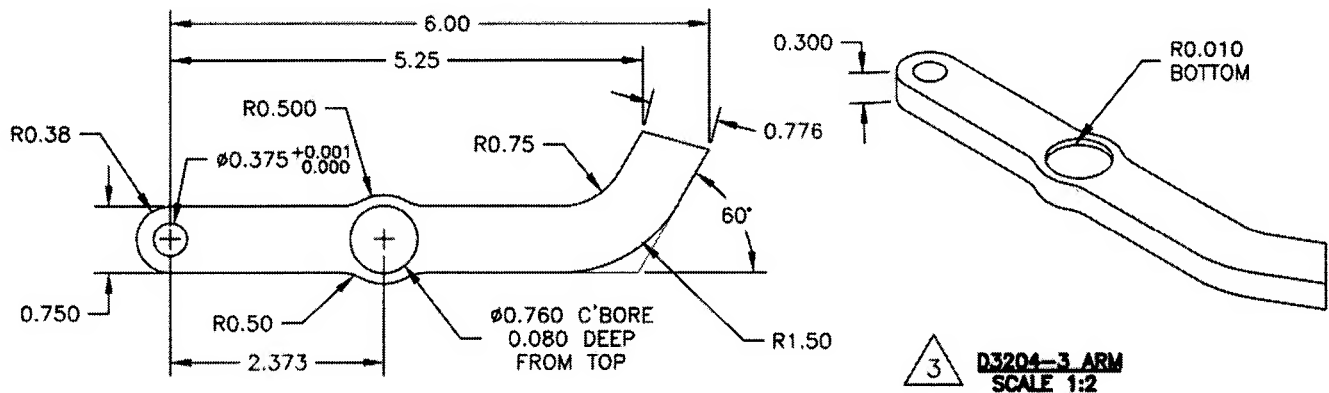
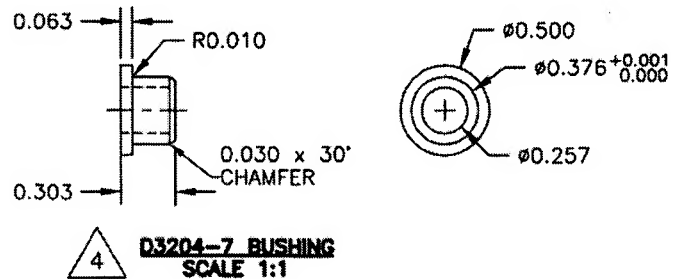
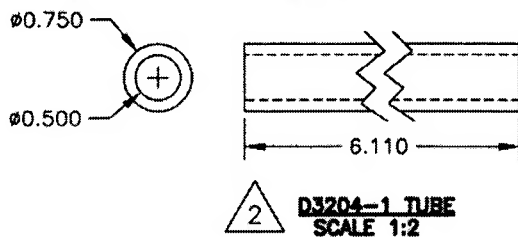
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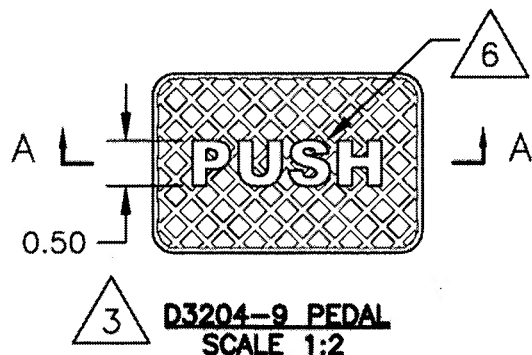
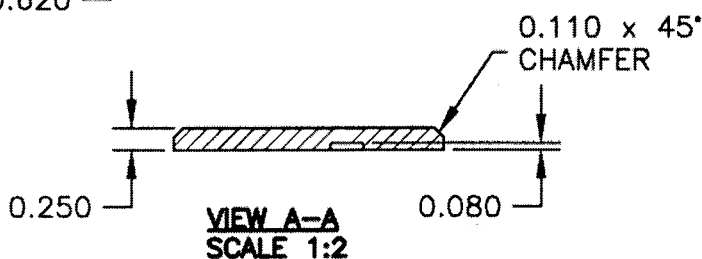
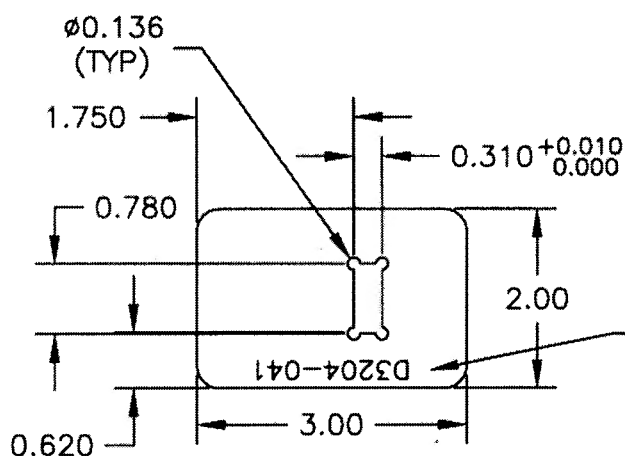
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